



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4462-1

Job Sheet 169550



Part No: D4462-1

Job Qty: 2 ea

Part Name: Baffle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV E SHEETS 1,2 IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC IPP REV:B 13.10.28 DWG REV PD1 DD VERF:JLM IPP REV:C 14.06.13 AS PER DWG REV:C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	1/18/18	1/18/18	0.00	0.00	Start Up Waterjet		SC 1/13/20
100	Waterjet	2 pcs	1/18/18	1/18/18	0.00	0.59	Waterjet1		SC 1/13/20
110	QC	2 pcs	1/18/18	1/18/18	0.00	0.00	QC2 Waterjet-3		SC 1/12/20
120	QC	2 pcs	1/18/18	1/18/18	0.00	0.00	QC8-4		38
130	Brake NC	2 pcs	1/18/18	1/18/18	0.18	0.58	Brake NC 2		8 DAS 38
140	QC	2 pcs	1/18/18	1/18/18	0.00	0.00	QC6		38
150	HandFinish	2 pcs	1/19/18	1/19/18	0.00	0.31	HandFinish1		2018 01/15 28
160	QC	2 pcs	1/19/18	1/19/18	0.00	0.00	QC7-3		38
170	Packaging	2 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3-2		38 18/01/17
180	QC21-SA	2 Ea	1/19/18	1/19/18	0.00	0.00	QC21		DAS 21 JAN 18 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.063 500 9814	4	391	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
Job No: 169550 Mfg Date: 12/20/17 Start up Operation D4462-1 Change No: Operation: Revision: PART NO: Battle S025826 DART AEROSPACE Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com				I / Supervisor				QA Coordinator Approval			
				Verification							
				Positioned Wrong				Outside Dimensions			
				Over/Under tolerance				Part Incorrect			
Part Lost/Missing				Part Moved							
Drawing				Finish							
Misread				Turning Sequence							
Misaligned/off center				Fit/Function							
Misaligned/off center				Misaligned/off center							

Root Cause			
Environment ☐	No Re-verification ☐	Pre: ☐	
Design ☐	Operator ☐	Ber ☐	
Doc/Data ☐	Offset/Setup ☐	Ce ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : ☐	

DART AEROSPACE LTD		Work Order: 169550
Description: Baffle		Part Number: D4462-1
Inspection Dwg: D4462	Rev: E	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	Ø0.129	1		Vit-A	
Ø0.768	+0.010/-0.001	Ø0.769	1		Tape	
Ø3.50	+0.012/-0.001	Ø3.50	1			
0.660	+/-0.010	0.664	1			
0.38	+/-0.030	0.388	1			
0.750	+/-0.010	0.751	1			
1.74	+/-0.030	1.749	1			
5.77	+/-0.030	5.775	1			
6.50	+/-0.030	6.506	1			
12.44	+/-0.030	12.445	1			
14.16	+/-0.030	14.168	1			
3.75	+/-0.030	3.755	1			
4.12	+/-0.030	4.13	1			
4.28	+/-0.030	4.28	1			
4.65	+/-0.030	4.654	1			
11.21	+/-0.030	11.215	1			
18.29	+/-0.030	18.29	1			
19.81	+/-0.030	19.81	1			
22.38	+/-0.030	22.386	1			
23.55	+/-0.030	23.56	1			
5.05	+/-0.030	5.05	1			
9.31	+/-0.030	9.31	1			
12.54	+/-0.030	12.546	1			

Measured by: 56	Checked by: 38	QC Inspector:
Date: 17/12/20	Date: DEC 28	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	12.05.15	Dimensions updated per Dwg Rev B	KJ	
C	13.05.08	Dwg Rev updated	KJ	
D	15.01.14	Dimensions updated per Dwg Rev C	KJ	
E	15.01.20	Dimensions updated per Dwg Rev E	KJ	



Dart Hawkesbury
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Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D4462-1 Revision: Baffle														
180	QC21-SA	S025826	169550	2 Ea	0	S025826	WA003		Stock	12/20/2017	Issue Container			
Operation Totals:		1		2	0									
Part Totals:		1		2	0									
Part Number: M6061T6S.063 Revision: 6061-T6 .063 Sheet														
100	Receive sf	S025825	169550	0 sf	0		MAT021		Stock	12/20/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		2	0									

Plex 1/19/2018 6:09 AM Dart.Lajeunesse.Marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							